

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007261**Date Inspected:** 06-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & TOWER Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

**BAY 5**

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #031 located on Floor Beam FB204 – 030. Welder is identified as 215185. ZPMC QC is identified as Chen Shi Ming. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – u4b – F.

FCAW process welding of weld joint #001 located on Traveler Rail TR015 – 015TB5 – 1. Welder is identified as 217291. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – P4 – F - 2.

**BAY 6**

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #005 located on NSD1 – PPSA4 – 3B/B. Welder is identified as 068764.

ZPMC QC is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3314.

SAW process welding of weld joint #01A located on ND1 – SA658 – 65m – 9. Welder is identified as 054458.

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ZPMC QC is identified as Shi Yu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – Tc – u5 – S – 1.

SMAW process welding of weld joint #018 located on WSD1 – PPSA4 – 13B/B. Welder is identified as 068918. ZPMC QC is identified as Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3312 – Tc – P5.

### BAY 7

#### Ultrasonic Testing

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Component. The weld designations reviewed are as follows:

1. SP3035 – 001 – 064; 001
2. SP3036 – 001 – 098; 067
3. SP3037 – 001 – 002; 085
4. SP3034 – 001 – 076; 077
5. SP3049 – 001 – 032

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #046 located on SP207A / PL215A. Welder is identified as 058174. ZPMC QC is identified as Zhong Chong Bia. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – u4b – F.

FCAW process welding of weld joint #012 located on SP207A/PL215A. Welder is identified as 054459. ZPMC QC is identified as Zhong Chong Bia. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

### BAY 9

#### Magnetic Particle Testing

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Component. The weld designations reviewed are as follows:

1. DP339 – 001 – 001 ~ 008
2. DP419 – 001 – 001 ~ 008

#### Visual Inspection

This QA inspector performed FVT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Component. The weld designations reviewed are as follows:

1. DP339 – 001 – 001 ~ 008 – Green Tag # 7663
2. DP419 – 001 – 001 ~ 008 – Green Tag # 7664

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Prue,Erik	QA Reviewer

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